	er ID 58867 y 19, 2010 3:27:44 PM										
Revision ID:	D412-709-011 Escape Panel Modification	A	Accept					Setup	Start Stop		
	5/19/2010 Start Qty: 2.00			Cust Item I Customer:	D:				Stop		
Approvals:	Process Plan: (1 Z	Date: <u>10/\$/19</u>	Tooling: SPC (Y/N):		nte:			Run	Start Stop		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
IIN-D412-709	Rev C		0.00								+r
DC Document Control	DOCUMENT CONTRO Memo Photocopy	DL bluefile & type labels per PPI	0.00	5 10 /oc/) r			 	v.		Ph
110 Packaging Packaging	Pick Kit Memo		0.00	•			10	6	- ス:	<u> </u>	/ (2x)
120 QC	QC4- 100% Inspect kits Memo	for completeness	0.00	/w/25			Œ.)			

Quality Control

Dart	Aer	osp	ace	Ltd
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W/0: 52	8867	WORK ORDER CHANGES			5		
DATE	STEP	Perm. Jange PROCEDURE CHANGE	Qtÿ	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	#	Part missing From who to part List. ADD missin part to 19th Scoloceles	,				
oloubs		D3561-1 B656109 aty +1 Parkit @ 140	SX	10.6.28			10/06bs
	#	uporte alo + Bim. ADD copy afrew uporte Bom As Reference.		,		-	
10/06/77	100		E	0.06.28			10/06/05

Part No: 1412-709-011 PAR #:	Fault Category:	NCR: Yes No DQA:_	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			Ì					
D.4.T.E.	0===	Description of NC		Corrective Action Section B		Verification	Ammuoval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	
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Work Order ID 58867

Wednesday, May 19, 2010 3:27:44 PM



Page 2

Item ID:

D412-709-011

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 5/26/2010

Escape Panel Modification

Start Date:

5/19/2010

Start Qty: 2.00

Reg'd Qty: 2.00



Cust Item ID: **Customer:**

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Accept

Qty

Stop



Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Packaging

Set Up/ Run Hours

0.00

0.00 Identify and pack for shipping as per PPP D412-709-011

6

Qty

Reject

Reject Number

Insp.

Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Chief Eng / Prod Mgr Approval QC Inspector DATE STEP **PROCEDURE CHANGE** Bv Qty Date Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: Date: _____ Resolution: _____ QA: N/C Closed: ___ Date: _____

		WORK ORDE	ER NON-CONFORMAN	NON-CONFORMANCE (NCR)					
	Description of NC		Corrective Action Section B		Verifica	tion	Annroyal	Approval QC Inspector	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng		
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							9		
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Chief Eng Chief	

•	Picklist Print Wednesday, May 79,	2010 3:27:	49 PM									Page 1
	Work Order ID: 588	367										——————————————————————————————————————
	Parent Item: D4	12-709-011										
	Parent Item Name:	Escape Panel	Modifi	cation	1 1841	ISSN SNIT OLONE ILON EINE	LFW W		li	s	tart Date: 5/19/2010	Required Date: 5/26/2010
	Comments:	IPP Rev:B IPP rev C	Remove	ed Manufacturing d sub-components	05- 5 07	11-06 JLM .11.12 EC				5	Start Qty: 2.00	Required Qty: 2.00
5 ₁ 2	Component Item ID/ Item Name AN6-20A Bolt	Replace Item ID		Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 120	Unit of Measure Each	Qty on Hand 43.0000	Qty per Kit Qty Issued	
						Location ST342		Loc	2 Oty 43	Loc Code		
~ D	AN960JD10L			Purchased	No	-	110915	120	43 Each	4,017.000	l (Maria emai)	6- 255
						Location		Loc	Oty	Loc Code		/
						ST348	110985	¥.	4017 4017		₹ ∀	
4	AN960JD616 // S//	49 00 66°	1	Purchased	No		110983	120	Each	0.0000	MII MII	- 49 88 106 25 8
	Washer AN960JD616L			Purchased	No			120	Each	. 124.0000	·** 5	7
1-12-	- 										STORILLIEGO.	C-32 S
						Location ST347		Loc	Oty	Loc Code		
				,			111819		124 124		10	
22	D3118-3 Sign Assembly			Manufactured	No	•		_ 120	Each	7.0000		0.6-256/26)
						Location		Loc	Qty	Loc Code		
						ST037	452 <u>65</u>		7 2			
						<	50365		5		2	

Dart Aerospace Ltd

W/O:					E 2 t				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No DO	2A:	Date: _	
	Re	solution:	Dispositio	n:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC Section A	Initial	on B		ication		Approval	
		Section A	Chief Eng	Action Description Chief Eng		sec ite	ction C	Chief Eng	QC Inspector
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Wednesday, May 19, 2010 3:27:49 PM

Work Order ID: 58867

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

05-11-06 JLM

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

07.11.12 EC Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty Qty on Qty per Kit Date Status Item Name Item ID Purch Item Location Measure Location Seq ID Hand Issued Issued D3136-043 No Manufactured 120 Each 2.0000 10-6-8 Window Assembly Location Loc Qty Loc Code ST216 2 2 D3224-1 Manufactured No 120 Each 10.0000 Location Loc Qty Loc Code ST217 ST218 D3237-1 Manufactured No 120 118.6680 8.166 Seal Retainer Location Loc Qty Loc Code ST414A 118.668 32825 11

(D3237-1-0980) cut (1) at 98.00" as per dwg ***per

kit***

107.668

43183

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								2 1
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									,	
Part No		PAR #:							_ Date: _	
	R	esolution:	_ Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:		· W	ORK OR	DER NON-CONFORM	MANCE	(NCR)				***************************************
DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description	ection B	Sign &	Verifica		Approval	Approval
		Occiona	Chief Eng	Chief Eng		Date	Section	_	Chief Eng	QC Inspector
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Wednesday, May 19, 2010 3:27:49 PM

Work Order ID: 58867

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

IPP rev C removed sub-components

05-11-06 JLM

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Oty: 2.00

Required Oty: 2.00

	emoved sub-components		.11.12 EC					nari Qiy. 2.00	r	kequired Qty: 2.0	U
Component Item ID/ Item Name D3237-3 Seal Filler Replacen Item ID	nent Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID 120	Unit of Measure f	Qty on Hand 39.6680	Qty per Kit 8.166	Qty Issued	Date Issued	Status
(D3237-3-0980) cut (1) at 98.00" as per dv kit***	9511) 0105128 +2 vg ***per		Location ST411	43140		<u>2ty</u> 668 668	Loc Code	_	JX	•	
D3239-1	Manufactured	No			120	Each	15.0000	² /	0-6.52	Q :	
MS21042L3	Purchased	No	Location ST046	55609	<u>Loc (</u>	0ty 15 15 Each	Loc Code 1,896.000	2	10.6.23	d/5	
1100			Location ST300		<u>Loc (</u> 1	<u>Oty</u> 896	Loc Code	· (_

20

376

1000

500

113537

113644

114523

114718

Dart Aerospace L	.td
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W/O:			\ <u>\</u>	ORK ORDER CHANG	EC					
DATE	STEP	PRO	OCEDURE CH		Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							Date:	
	R	esolution:	Dispositi	on:	_ QA: N/C	Clos	sed:	ļ	Date:	
NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sig	ın & ate	Verificate Section		Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, May 19, 2010 3:27:49 PM

Page 4

Status

Work Order ID: 58867

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

Purchased

removed sub-components

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Oty: 2.00

Required Otv: 2.00

Component Item Item Name MS21042L6 Nut	Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 120	Unit of Measure Each	Qty on Hand 363.0000	Qty per Ki	it Qty Issued //U - G - 3 S	_
				Location		Loc O	<u>Oty</u>	Loc Code			
				ST300			363				
				_	111578		163			6	
				_	114495		200				

05-11-06 JLM

07.11.12 EC

No

MS35207-262

Location Loc Qty Loc Code ST295 24 109840 24

120

Each

24.0000

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W/O:			W	ORK ORDER CHANG	ES				sa! . ∉	
DATE	STEP	PR	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			1							
Part No	:	PAR #:	Fault Cate	_ NCR: Yes	R: Yes No DQA:		Date:			
	R	esolution:	Disposition	on:	_ QA: N/C Closed:			Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC		Corrective Action Section		Verifica	on	Approval	Approval	
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector	
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DART AEROSPACE LTD.



IIN-D412-709 Page 12 of 12

5.0 PARTS LIST

· * 17.3

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
Х							D412-709-011 ESCAPE PANEL MODIFICATIO	
_1	Χ.	- *¥					D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		Х					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	Х				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				Х			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
	ta arti	ξί. 			X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
	, A 🟳	, <			1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			- · · · · · · · · · · · · · · · · · · ·				D2126-0720	LOCKING SEAL
	<u> </u>		.1.				D3118-3	SIGN ASSEMBLY
1				1			D3116-3	WINDOW ASSEMBLY
							D3136-041	WINDOW ASSEMBLY
4	1						D3136-043	FRAME
1			1				D3224-1	WINDOW
	 		1	_		1	D3230-1 D3237-1-0720	SEAL RETAINER
	1			1		!	D3237-1-0720	SEAL RETAINER
	<u> </u>			, , ,		1	D3237-1-0900 D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0720	SEAL FILLER
*2	 			<u>'</u>			D3239-1	COVER
		1		7			D3240-1	FRAME
		· į				1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
	()	,			1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1)	4		. 1,		1	D3561-1	WINDOW SEAL TOOL
					-			
′ 3							AN6-20A	!BOLT
. 2							AN960JD10L	WASHER
: 5							AN960JD616	WASHER
. 5				,			AN960JD616L	WASHER
. 2 .						-	MS21042L3	NUT
_ 3							MS21042L6	NUT
, 2							MS35207-262	SCREW
 -							146	

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** Ву DATE STEP Qty PROCEDURE CHANGE Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification Description of NC **Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng